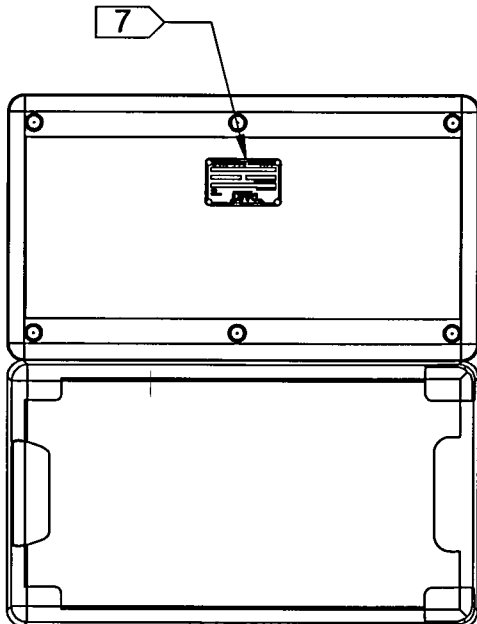
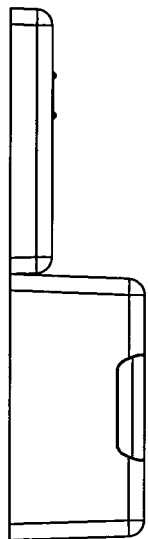
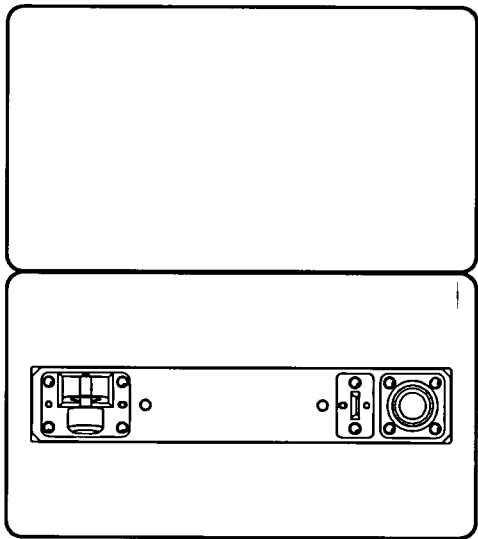
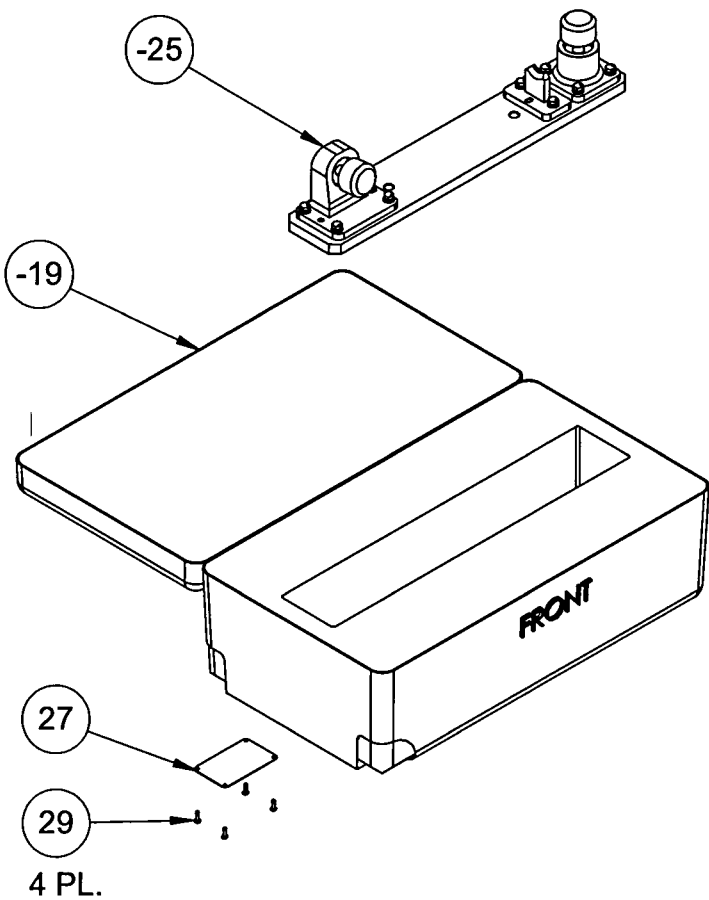


ITEM #	QTY	PART #	TITLE	PG
-19	1	RBEM623U4003102-19	CASE ASSY	8
-25	1	RBEM623U4003102-25	PITCH ROD LENGTH ADJUSTMENT ASSY	2
27	1	RB41011	DART PLACARD	-
29	4	McMaster#97524A032	RIVET 1/8" x 0.425" LG.	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	RELEASE FOR PRODUCTION	-	2/22/2017	RJC	JAG
B	-7 WELDMENT IS ONE MACHINED PART, DELETED 7A & 7B, ADDED -25 ASSEMBLY, TEMPLATE UPDATED AS PER HAWKESBURY STANDARDS	17-680	17.09.27	VM	WM



**RBEM623U4003102 PITCH ROD LENGTH ADJUSTMENT TOOL**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) SPEC: N/A
  - 5) BREAK ALL SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) LOCATE AND INSTALL DART PLACARD RB41011 ON PELICAN CASE LID AT APPROXIMATE CENTERED LOCATION AS SHOWN

<b>DART</b> AEROSPACE		Hawkesbury, Ontario, Canada	
TITLE <b>PITCH ROD LENGTH ADJUSTMENT TOOL</b>			
DWG NO. <b>RBEM623U4003102</b>		REV <b>B</b>	
DESIGN BY:	VM 9/26/2017	.XXX ± .005	FRACTIONS ± 1/8
DRAWN BY:	VM 09/28/2017	.XX ± .01	ANGLES ± 5°
CHECKED:	SAC 09/28/2017	.X ± .1	SURFACES ± 125
MFG. APPR:	DP 09/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 10/03/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	N/A
		SHEET 1 OF 10	
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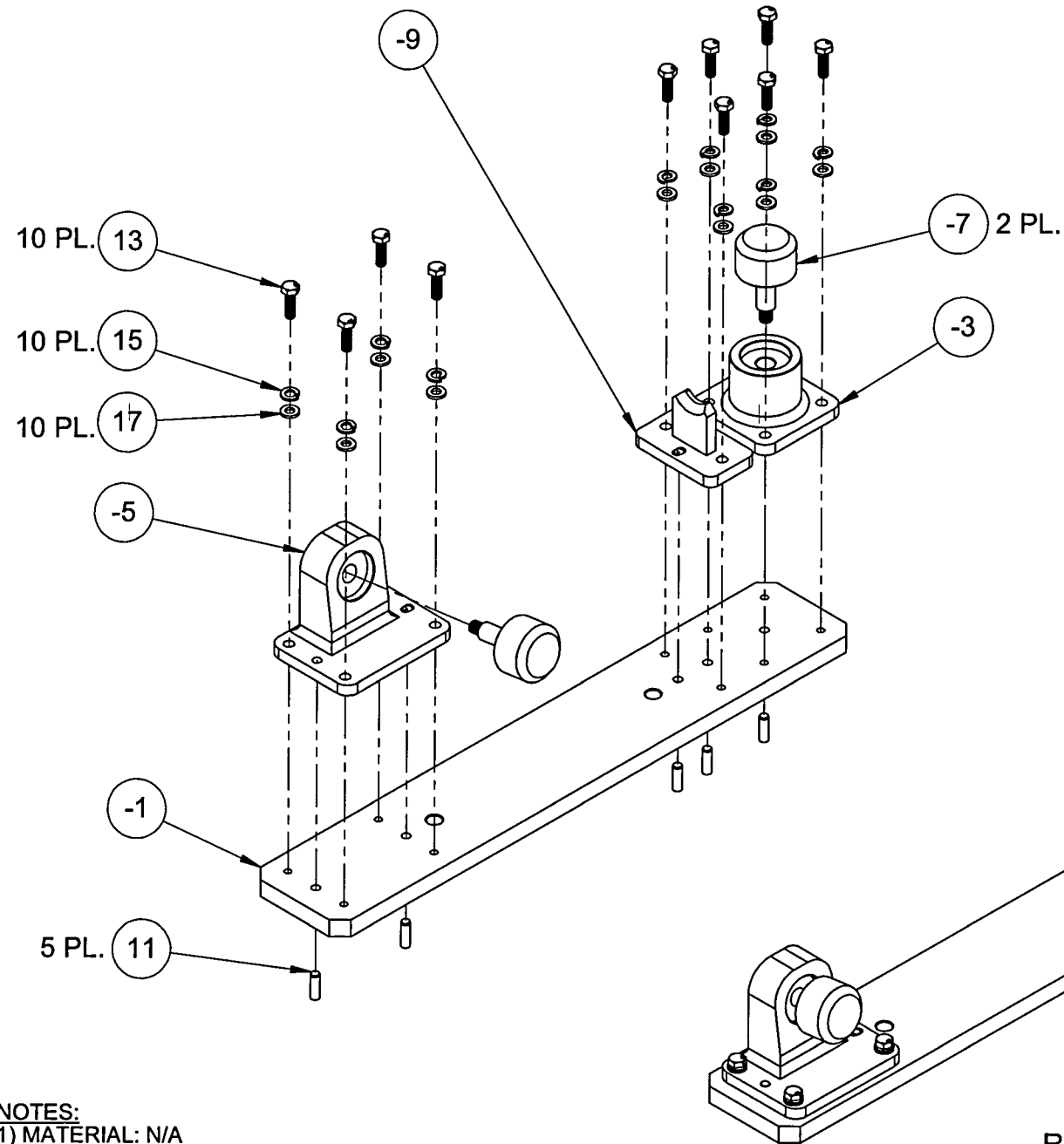
ITEM #	QTY	PART #	TITLE	PG
-1	1	RBEM623U4003102-1	BASE	3
-3	1	RBEM623U4003102-3	POST	4
-5	1	RBEM623U4003102-5	SEAT	5
-7	2	RBEM623U4003102-7	THUMB SCREW	6
-9	1	RBEM623U4003102-9	STAND	7
11	5	McMaster#91595A452	DOWEL PIN M6 x 20mm LG.	-
13	10	McMaster#91280A330	HEX HEAD SCREW M6 x 1mm x 20mm LG.	-
15	10	McMaster#91202A234	SPLIT LOCK WASHER M6	-
17	10	McMaster#91166A250	FLAT WASHER M6	-

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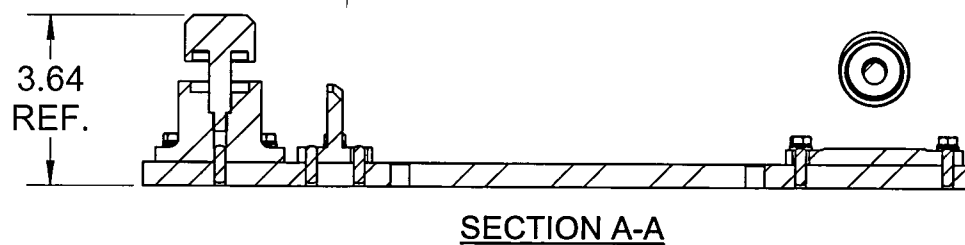
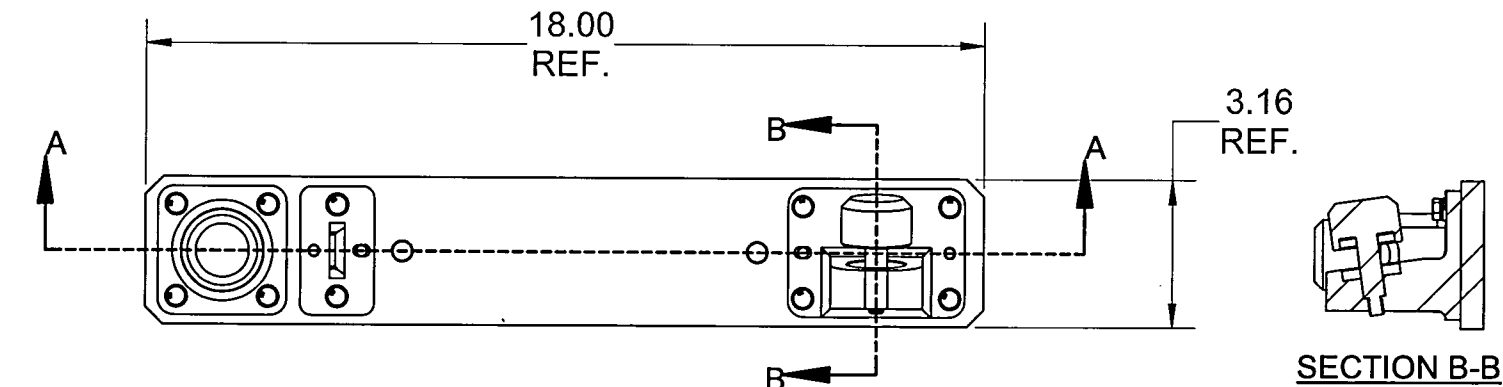
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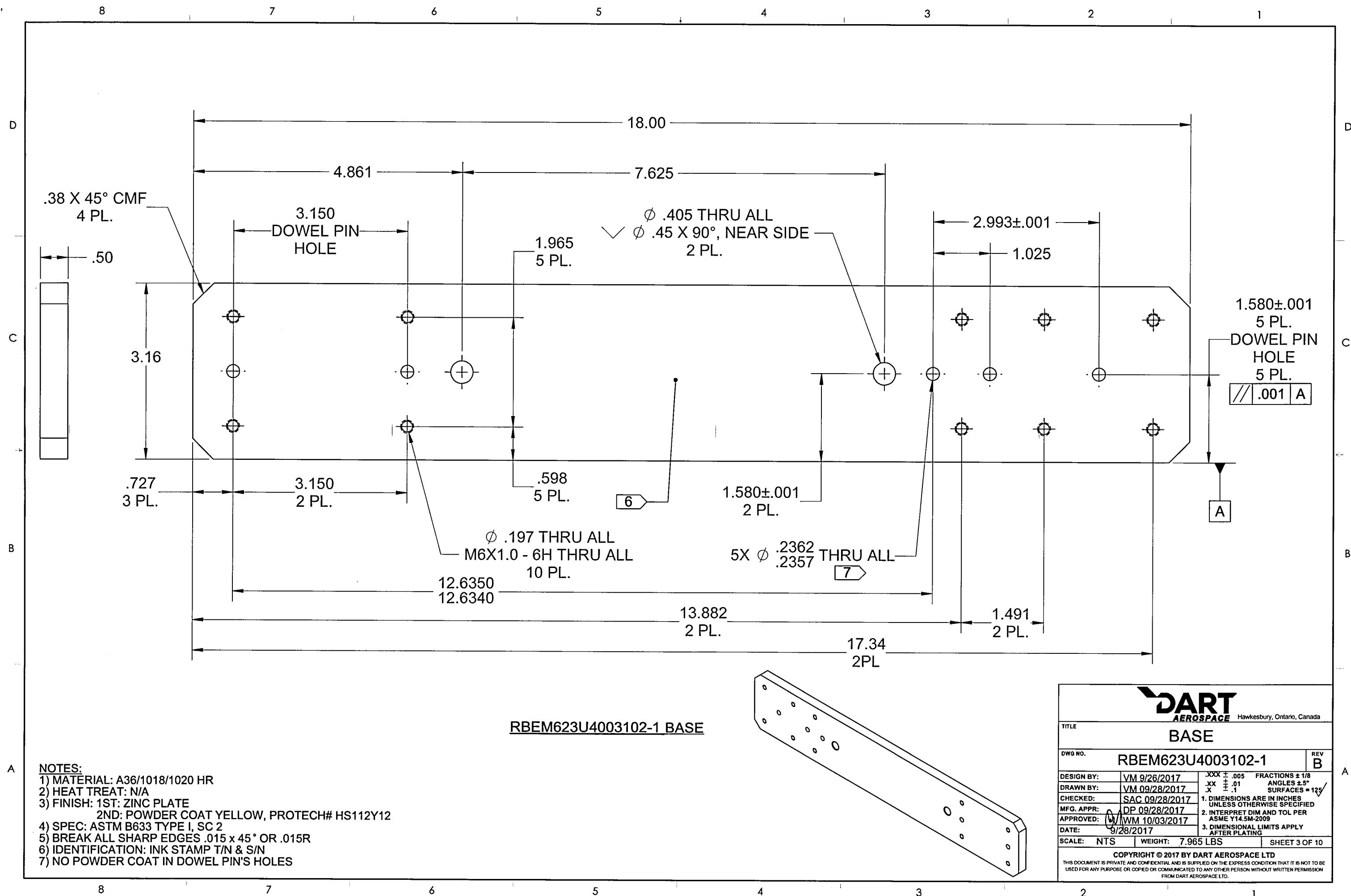


NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) SPEC: N/A  
5) BREAK ALL SHARP EDGES: N/A  
6) IDENTIFICATION: N/A

RBEM623U4003102-25 PITCH ROD LENGTH ADJUSTMENT ASSY



<b>DART</b> AEROSPACE Hawkesbury, Ontario, Canada			
TITLE PITCH ROD LENGTH ADJUSTMENT ASSY			
DWG NO. RBEM623U4003102-25			REV B
DESIGN BY:	VM 9/26/2017	.XXX ± .005 FRACTIONS ± 1/8	
DRAWN BY:	VM 09/28/2017	.XX ± .01 ANGLES ± 5°	
CHECKED:	SAC 09/28/2017	.X ± .1 SURFACES = 125	
MFG. APPR:	DP 09/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 10/03/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	N/A
		SHEET 2 OF 10	
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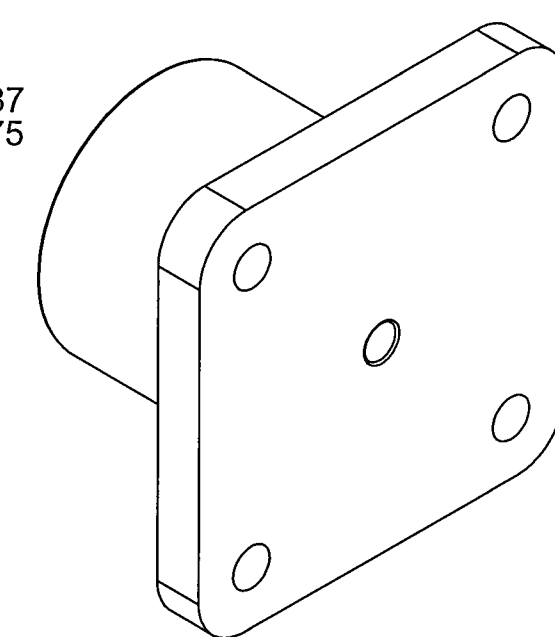
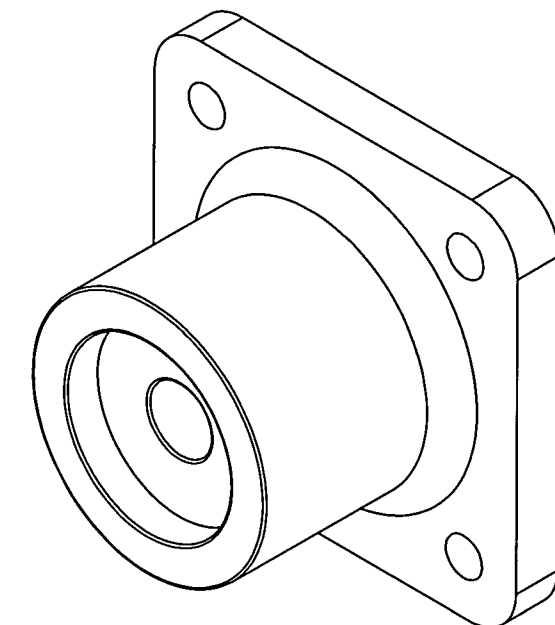
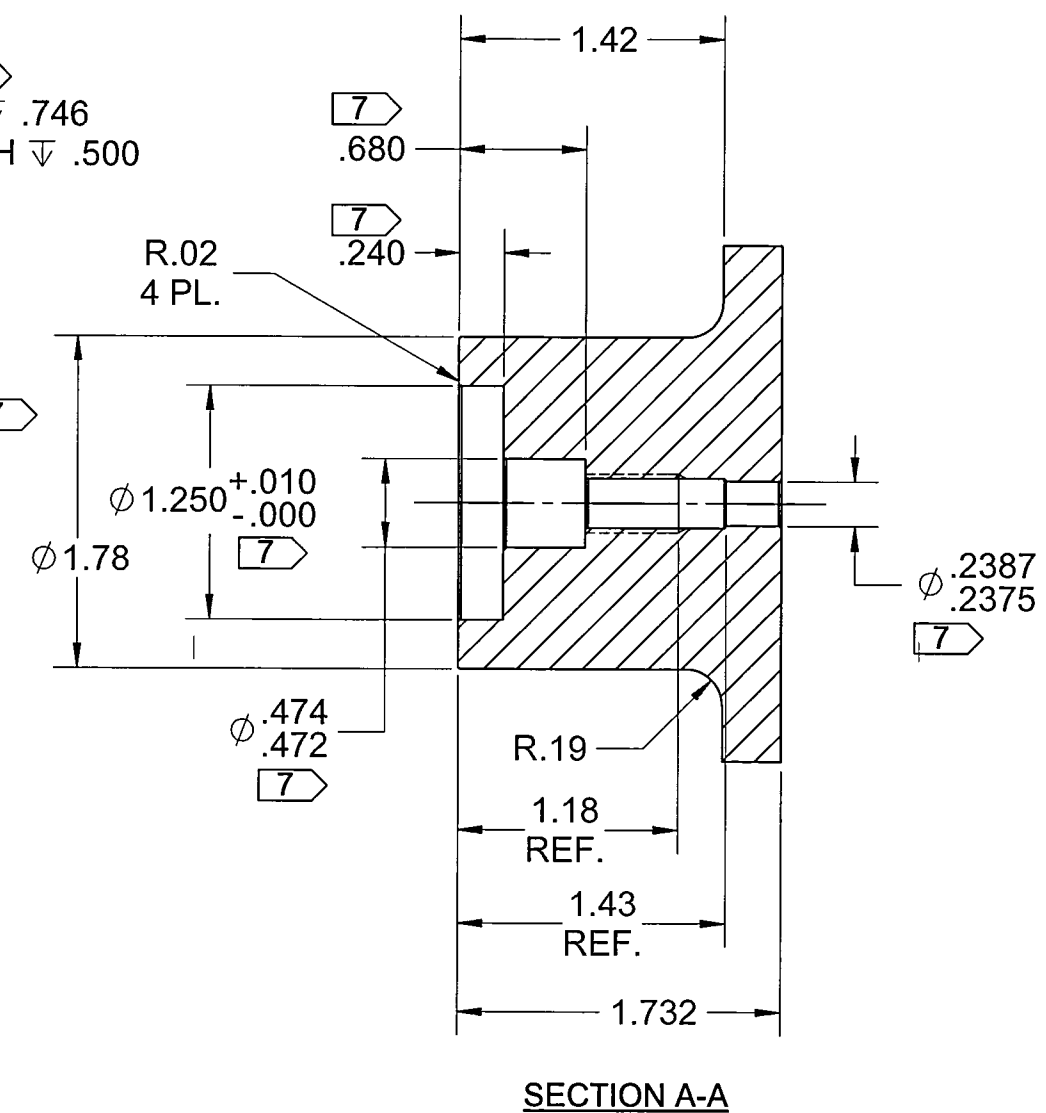
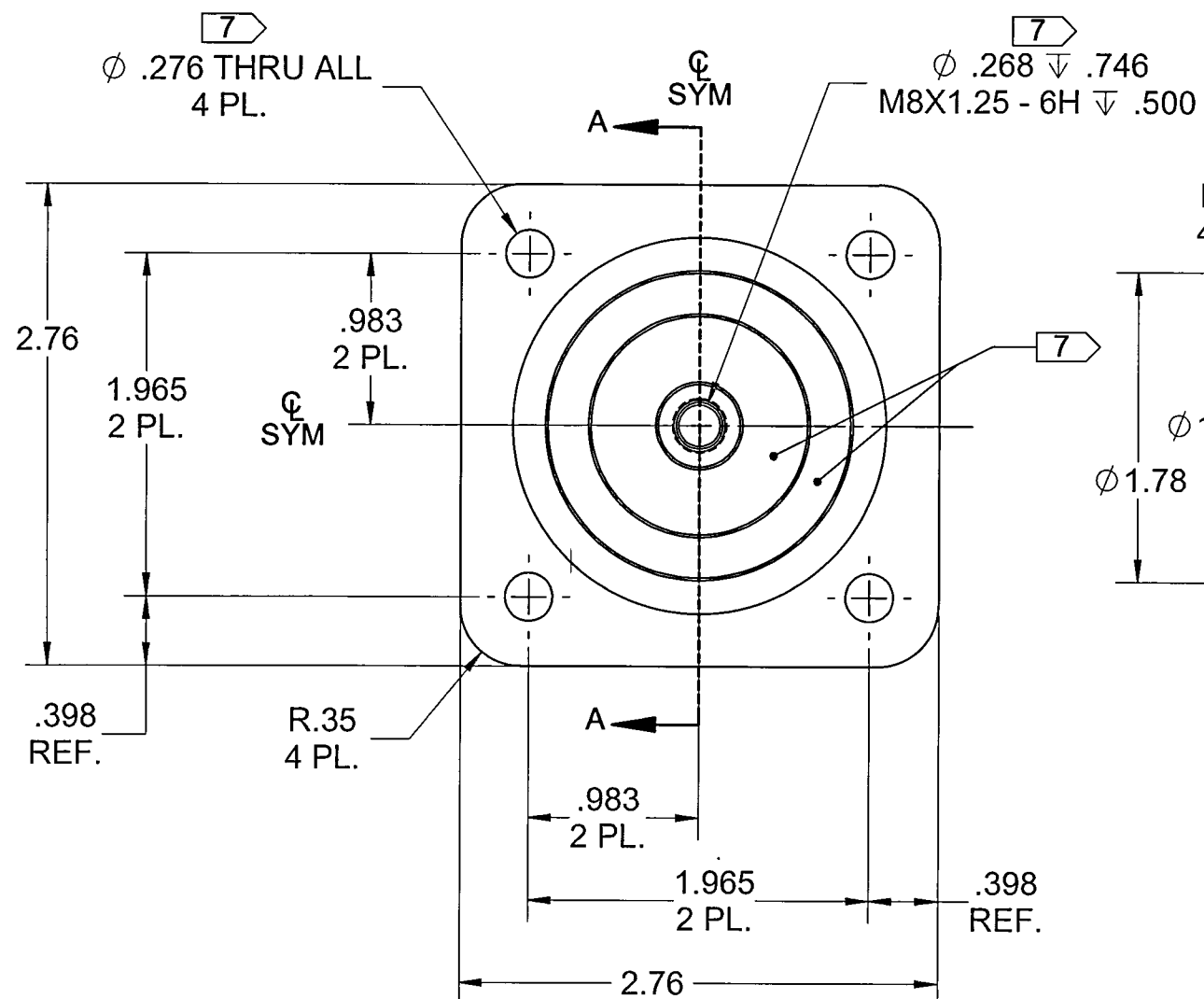
8 7 6 5 4 3 2 1

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**RBEM623U4003102-3 POST**

- NOTES:
- 1) MATERIAL: A36/1018/1020 HR
  - 2) HEAT TREAT: N/A
  - 3) FINISH: 1ST: ZINC PLATE  
2ND: POWDER COAT YELLOW, PROTECH# HS112Y12
  - 4) SPEC: ASTM B633 TYPE I, SC 2
  - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
  - 6) IDENTIFICATION: N/A
  - 7) NO POWDER COAT THIS SURFACE

<b>DART AEROSPACE</b> Hawkesbury, Ontario, Canada			
TITLE <b>POST</b>			
DWG NO. <b>RBEM623U4003102-3</b>			REV <b>B</b>
DESIGN BY:	VM 9/26/2017	.XXX $\pm .005$ FRACTIONS $\pm 1/8$	
DRAWN BY:	VM 09/28/2017	.XX $\pm .01$ ANGLES $\pm 5^\circ$	
CHECKED:	SAC 09/28/2017	.X $\pm .1$ SURFACES = 125	
MFG. APPR:	DP 09/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 10/03/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	1.545 LBS
		SHEET 4 OF 10	
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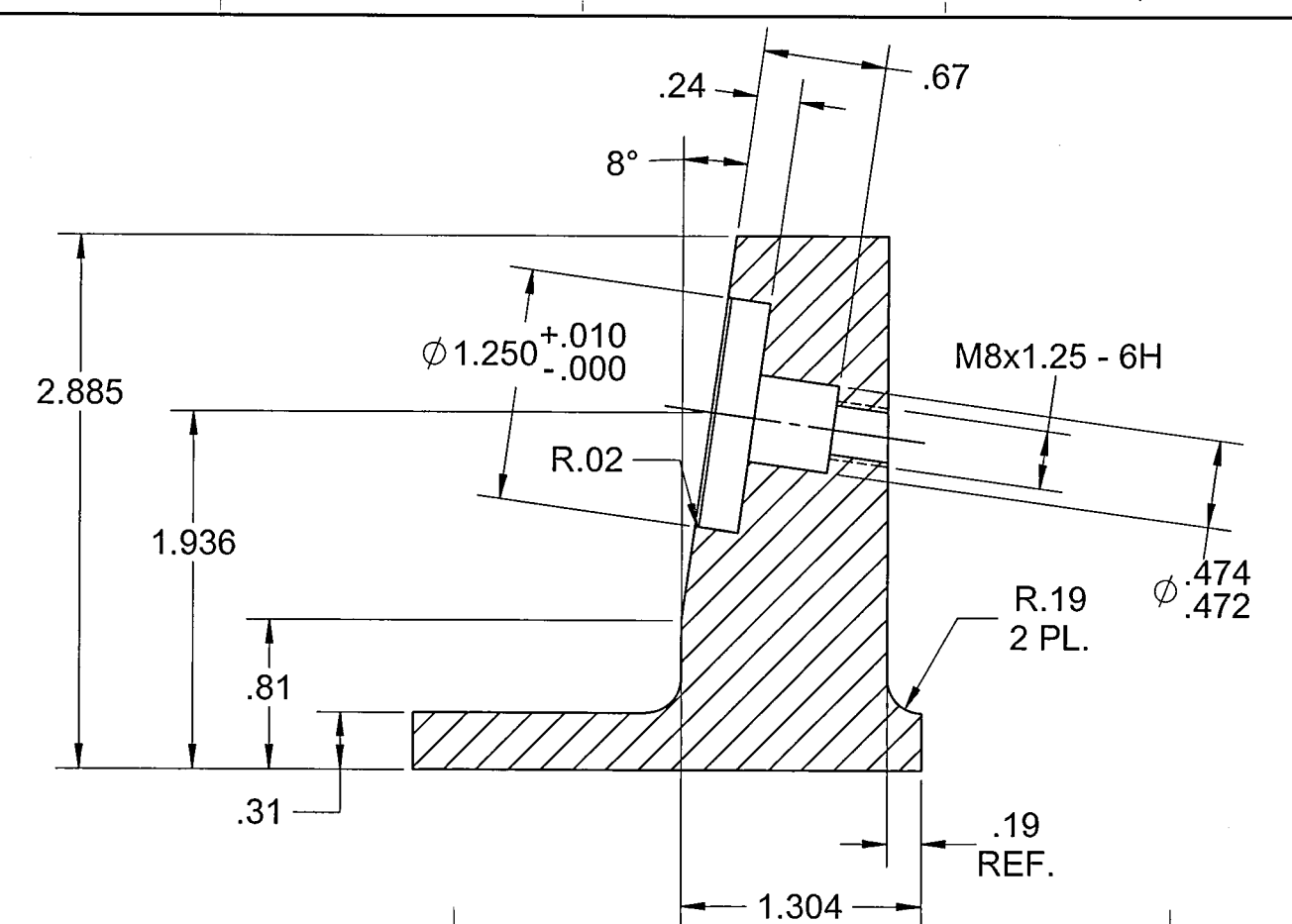
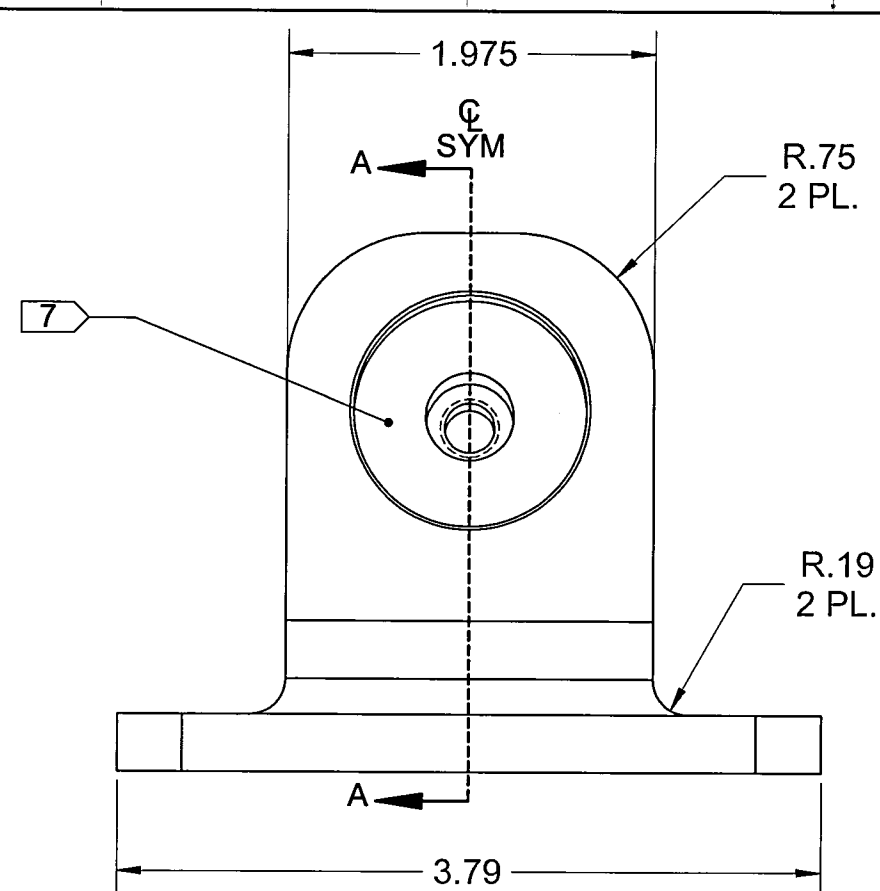
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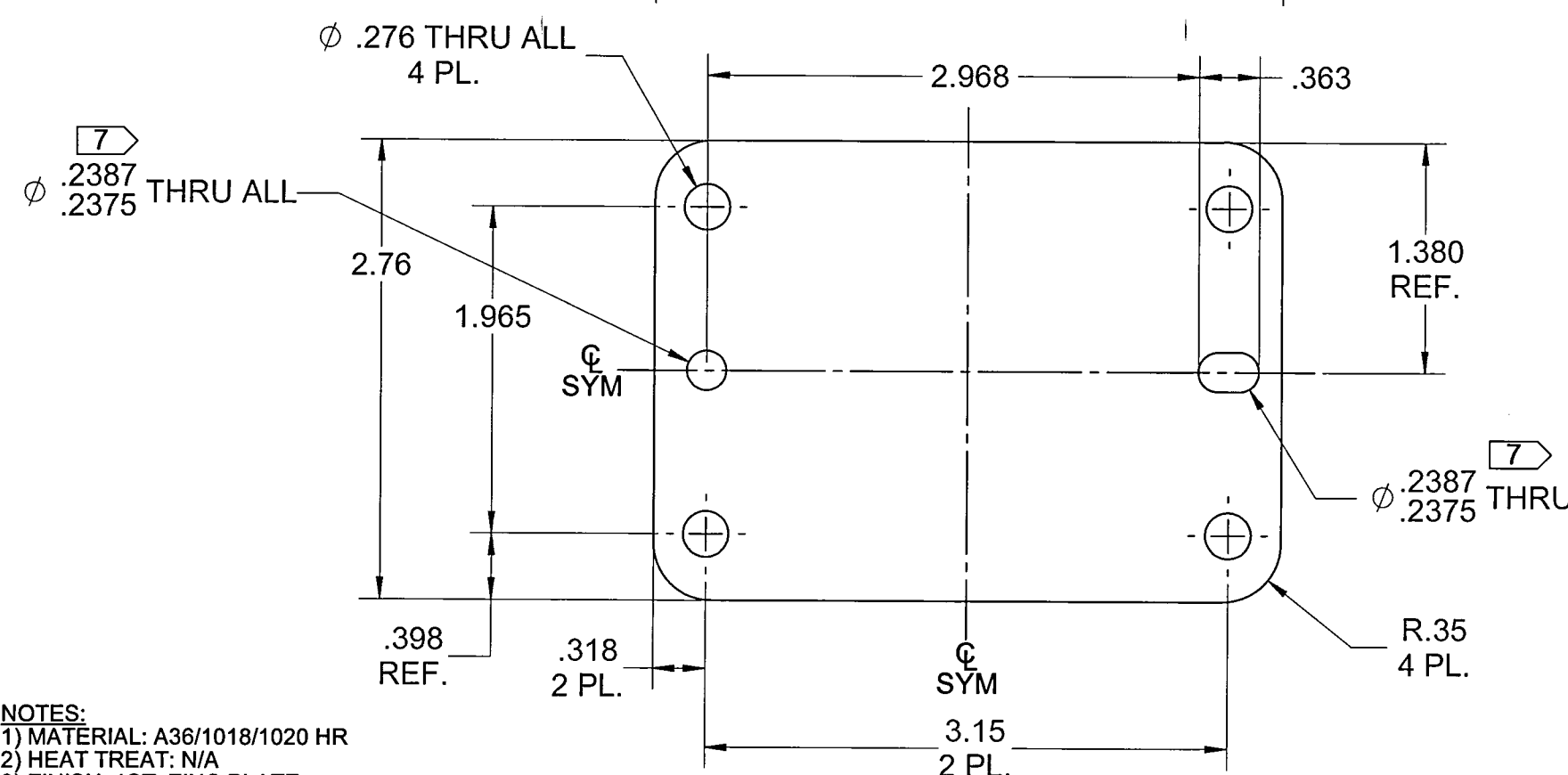
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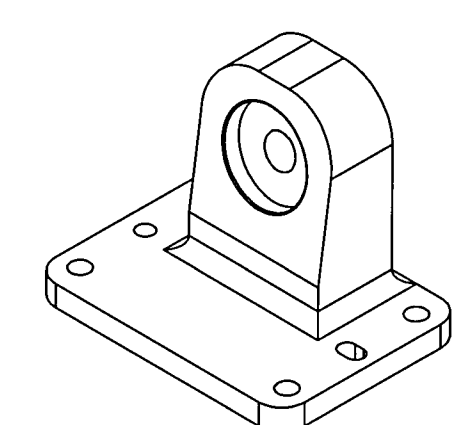
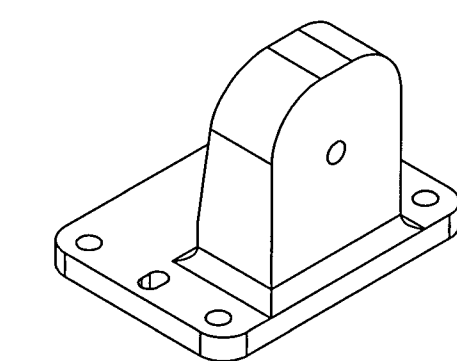


SECTION A-A



- NOTES:
- 1) MATERIAL: A36/1018/1020 HR
  - 2) HEAT TREAT: N/A
  - 3) FINISH: 1ST: ZINC PLATE  
2ND: POWDER COAT YELLOW, PROTECH# HS112Y12
  - 4) SPEC: ASTM B633 TYPE I, SC 2
  - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
  - 6) IDENTIFICATION: N/A
  - 7) NO POWDER COAT THIS SURFACE

RBEM623U4003102-5 SEAT



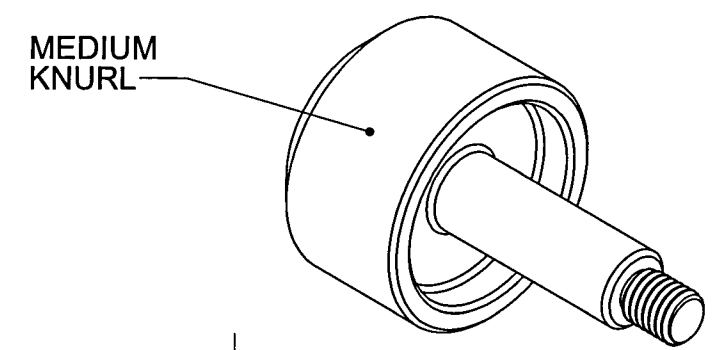
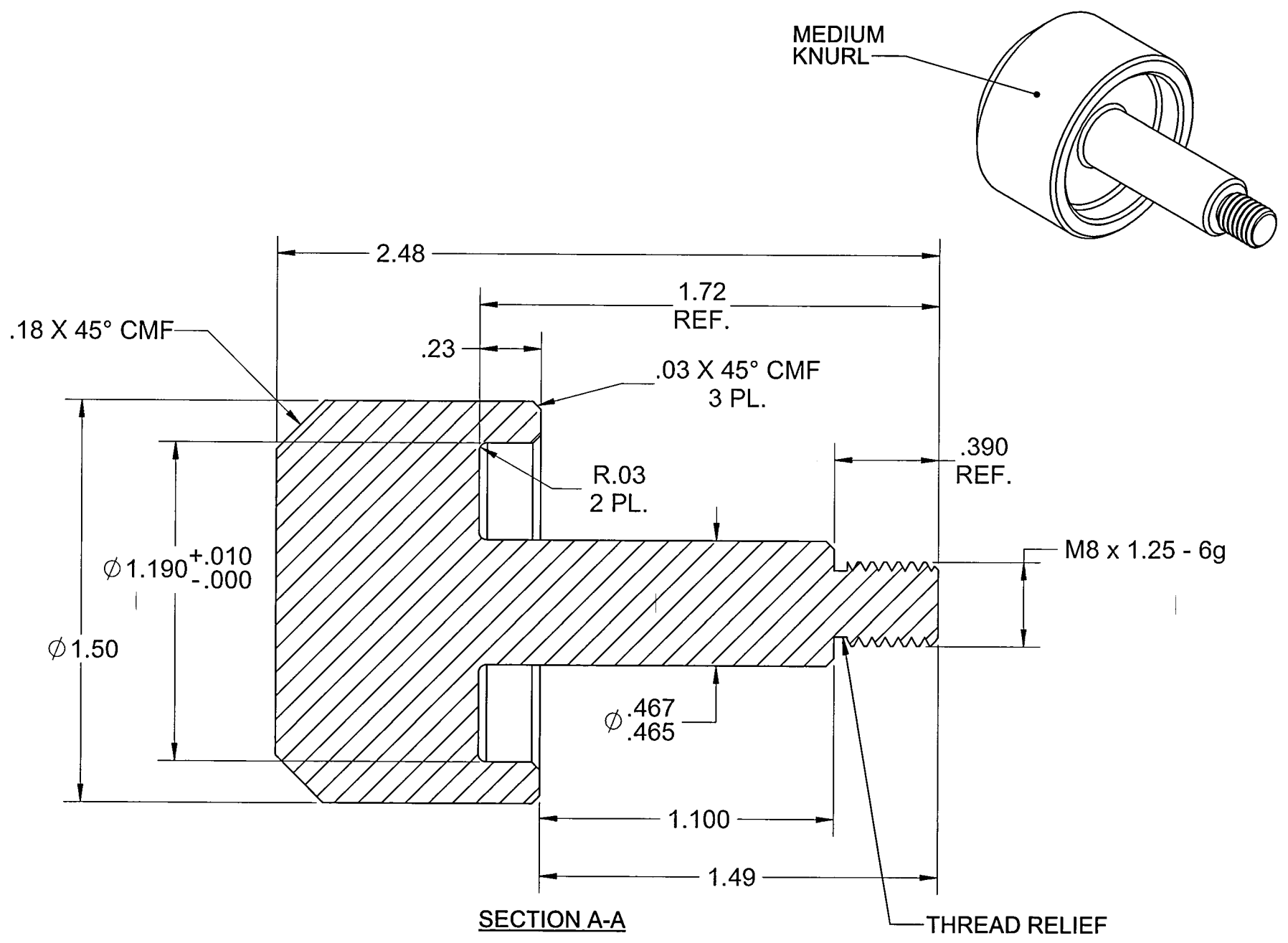
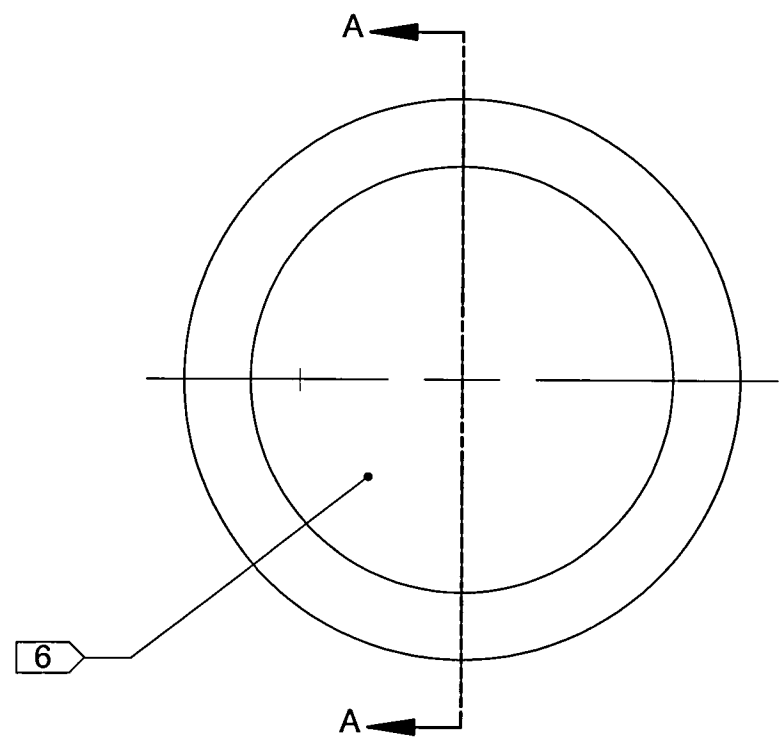
<b>DART AEROSPACE</b> Hawkesbury, Ontario, Canada			
TITLE <b>SEAT</b>			
DWG NO. <b>RBEM623U4003102-5</b>			REV <b>B</b>
DESIGN BY:	VM 9/26/2017	XXX ± .005 FRACTIONS ± 1/8	
DRAWN BY:	VM 09/28/2017	XX ± .01 ANGLES ± 5°	
CHECKED:	SAC 09/28/2017	X ± .1 SURFACES = 125	
MFG. APPR:	DP 09/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 10/03/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	2.184 LBS
		SHEET 5 OF 10	
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8 7 6 5 4 3 2 1


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**RBEM623U4003102-7 THUMB SCREW**

- NOTES:**  
1) MATERIAL: AISI 304/316 SS  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) SPEC: N/A  
5) BREAK ALL SHARP EDGES .015 x 45° OR .015R  
6) IDENTIFICATION: AS PER QSI 044

 <b>DART</b> AEROSPACE Hawkesbury, Ontario, Canada			
TITLE <b>THUMB SCREW</b>			
DWG NO. <b>RBEM623U4003102-7</b>			REV <b>B</b>
DESIGN BY:	VM 9/26/2017	.XXX ± .005 FRACTIONS ± 1/8	
DRAWN BY:	VM 09/28/2017	.XX ± .01 ANGLES ± 5°	
CHECKED:	SAC 09/28/2017	.X ± .1 SURFACES = 125	
MFG. APPR:	DP 09/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	VM 10/03/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	0.5 LBS
		SHEET 6 OF 10	
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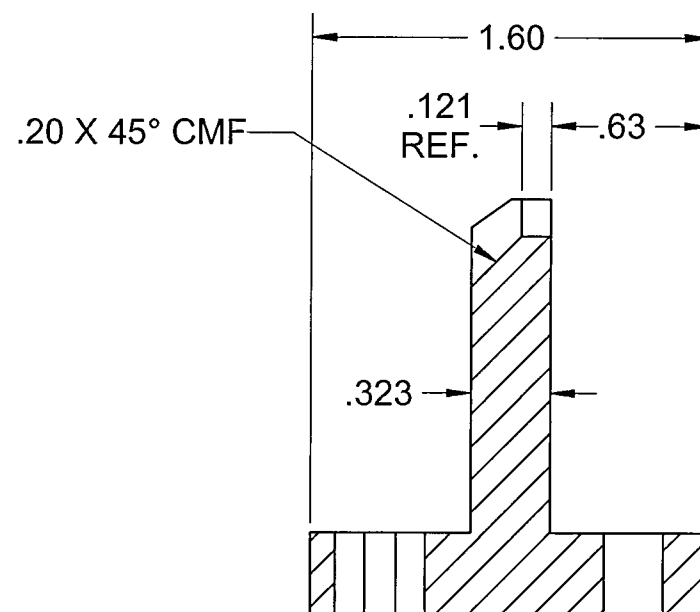
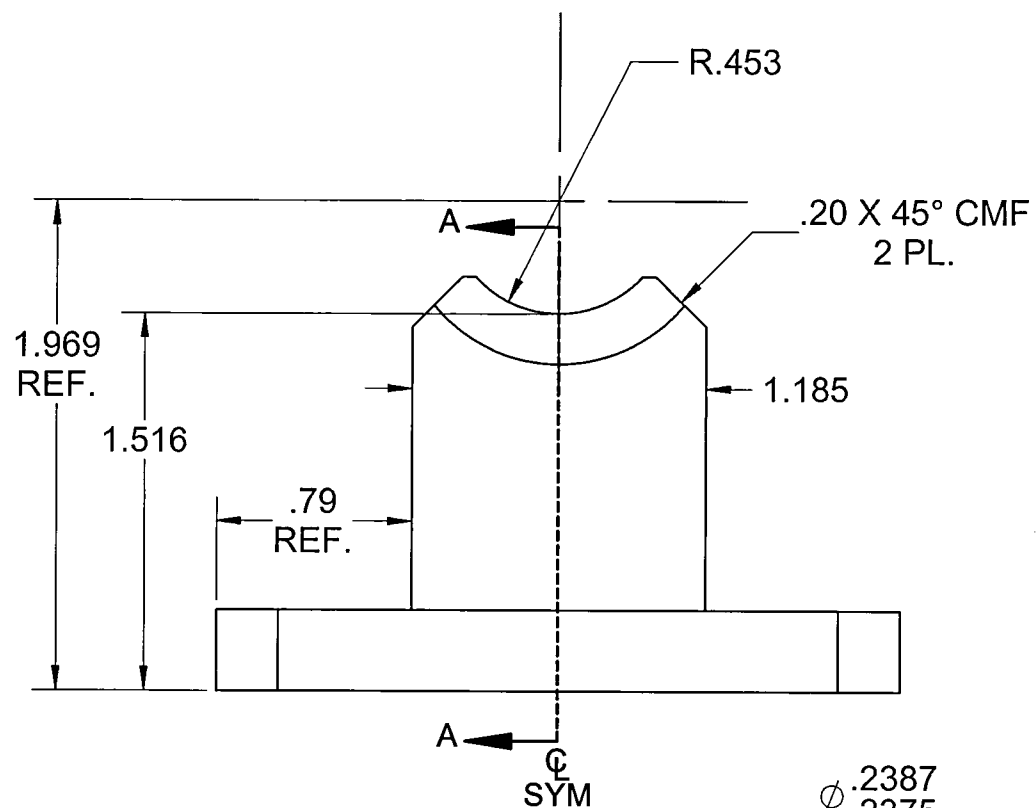
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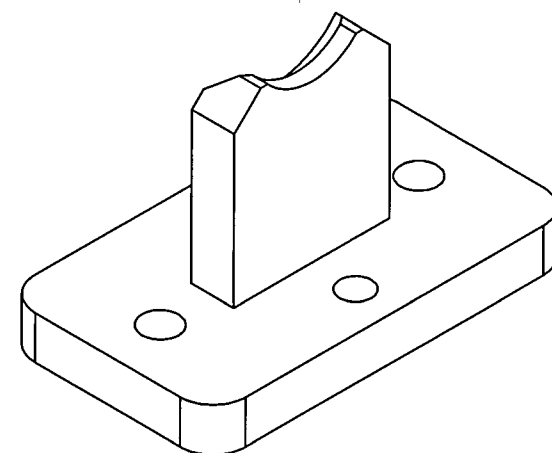
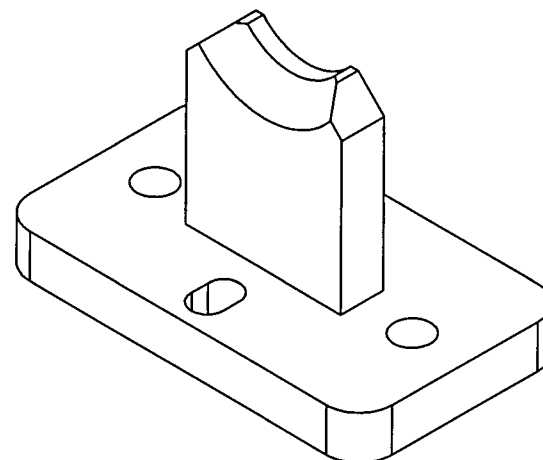
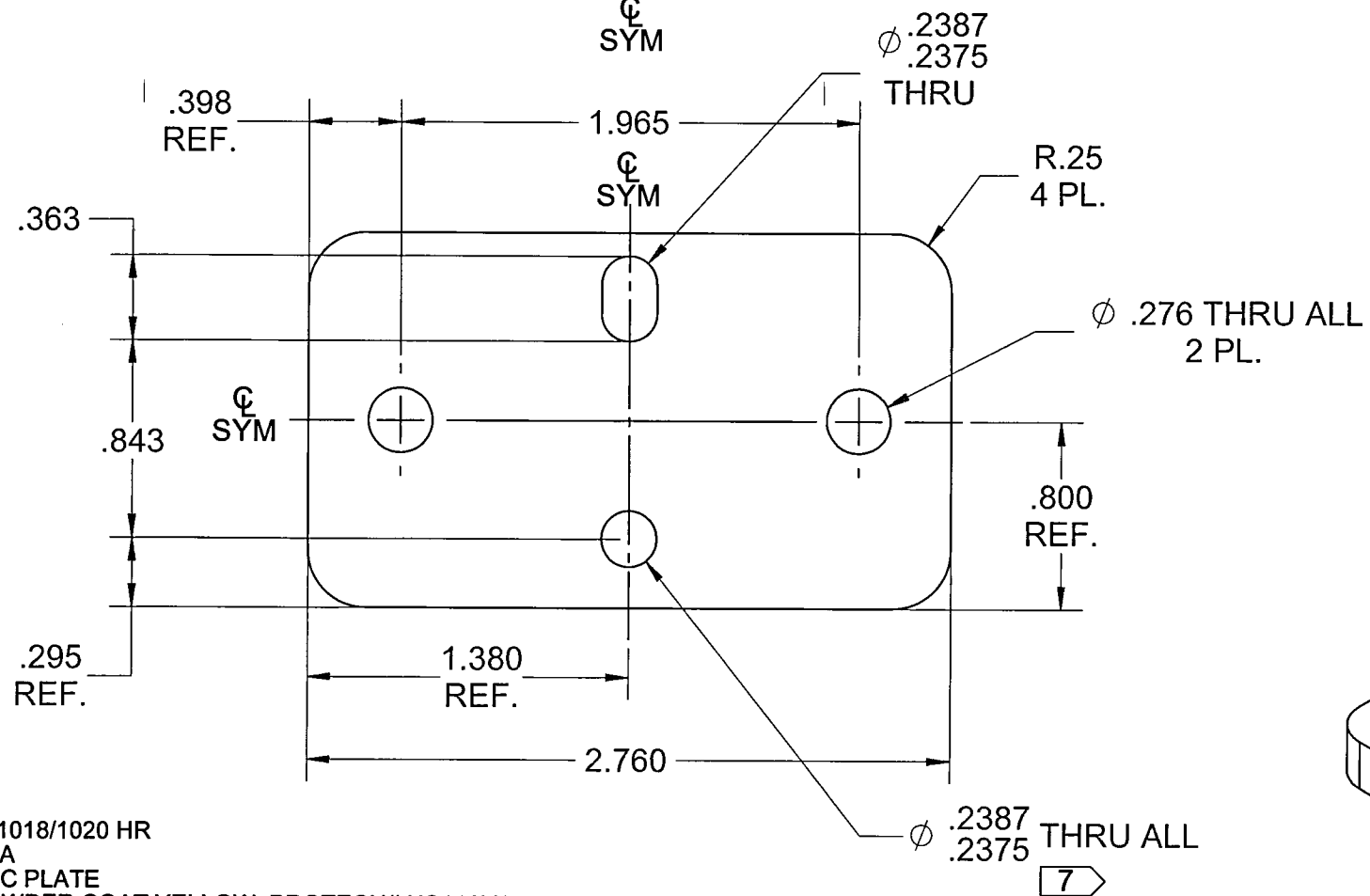
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SECTION A-A



## NOTES:

- 1) MATERIAL: A36/1018/1020 HR
- 2) HEAT TREAT: N/A
- 3) FINISH: 1ST: ZINC PLATE  
2ND: POWDER COAT YELLOW, PROTECH# HS112Y12
- 4) SPEC: ASTM B633 TYPE I, SC 2
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: N/A
- 7) NO POWDER COAT IN DOWEL PIN'S HOLES

RBEM623U4003102-9 STAND

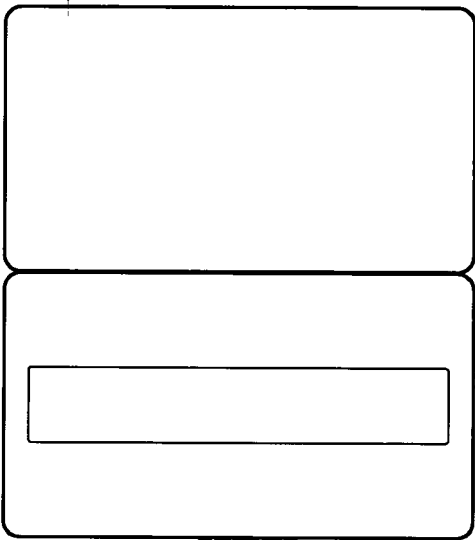
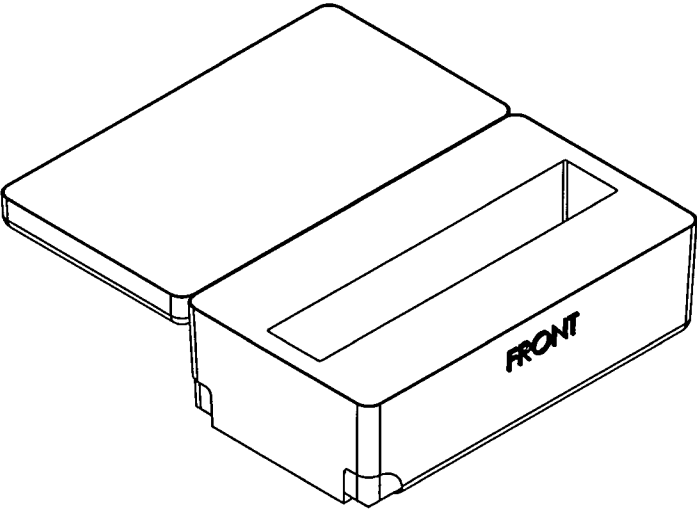
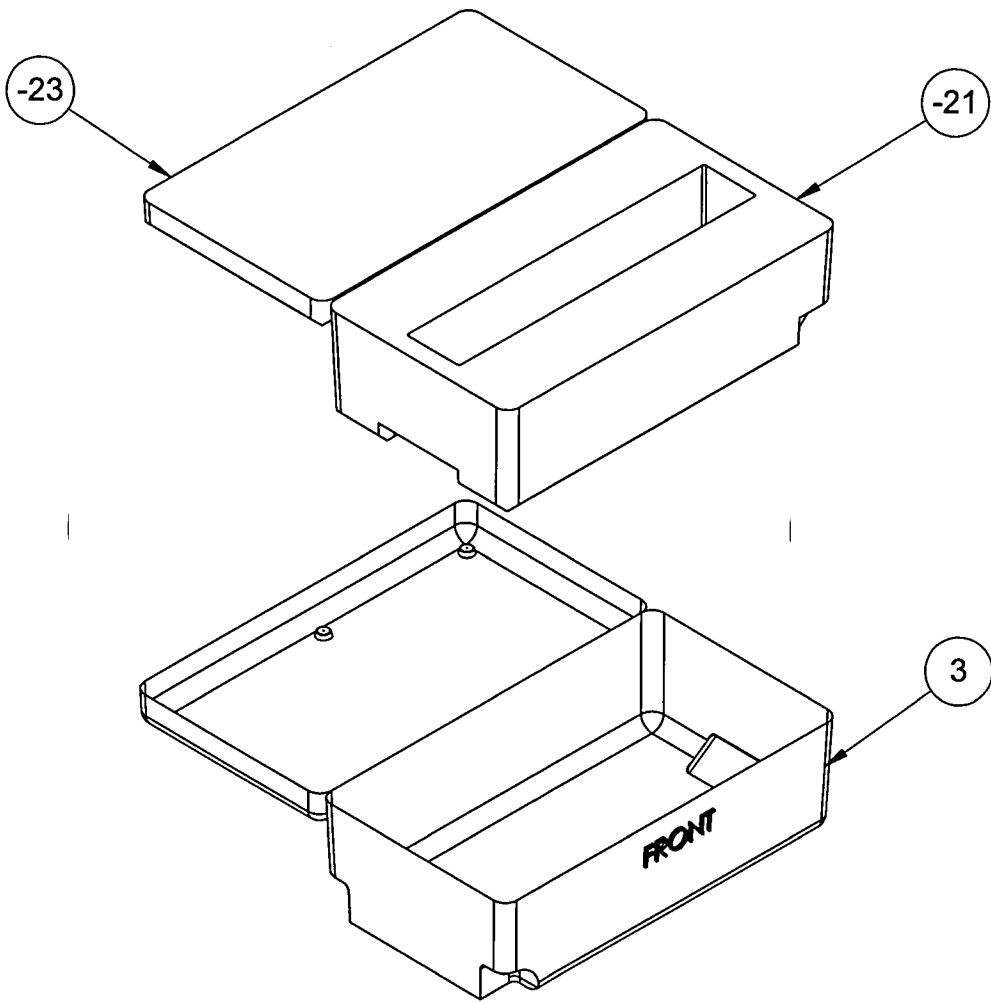
**DART**  
**AEROSPACE**

Hawkesbury, Ontario, Canada

TITLE		
STAND		
DWG NO.	REV	
RBEM623U4003102-9	B	
DESIGN BY:	VM 9/26/2017	.XXX ± .005 FRACTIONS ± 1/8
DRAWN BY:	VM 09/28/2017	.XX ± .01 ANGLES ± 5°
CHECKED:	SAC 09/28/2017	.X ± .1 SURFACES = 125
MFG. APPR:	DP 09/28/2017	1. DIMENSIONS ARE IN INCHES
APPROVED:	WM 10/03/2017	2. INTERPRET DIM AND TOL PER
DATE:	9/28/2017	ASME Y14.5M-2009
SCALE:	NTS	3. DIMENSIONAL LIMITS APPLY
WEIGHT:	0.513 LBS	AFTER PLATING
SHEET 7 OF 10		

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ITEM #	QTY	PART #	TITLE	PG
-21	1	RBEM623U4003102-21	BOTTOM TOOL CUSHION	9
-23	1	RBEM623U4003102-23	TOP TOOL CUSHION	10
3	1	PELICAN #APP-1510-E	PELICAN #APP-1510-E	-

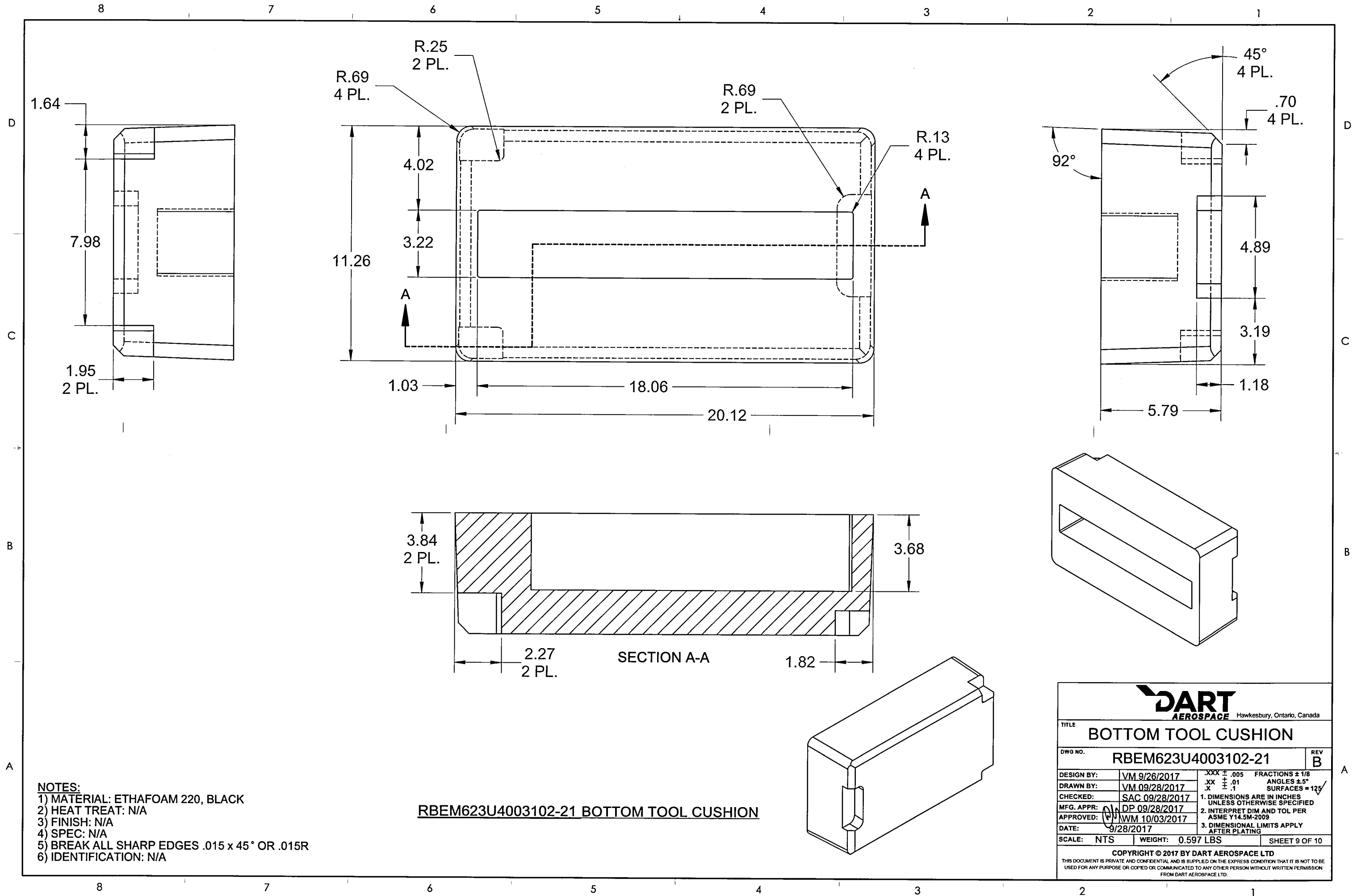


RBEM623U4003102-19 CASE ASSY

- NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) SPEC: N/A  
5) BREAK ALL SHARP EDGES: N/A  
6) IDENTIFICATION: N/A

<b>DART</b> AEROSPACE Hawkesbury, Ontario, Canada			
TITLE <b>CASE ASSY</b>			
DWG NO. <b>RBEM623U4003102-19</b>			REV <b>B</b>
DESIGN BY:	VM 9/26/2017	.XXX ± .005	FRACTIONS ± 1/8
DRAWN BY:	VM 09/28/2017	.XX ± .01	ANGLES ± 5°
CHECKED:	SAC 09/28/2017	.X ± .1	SURFACES = 125
MFG. APPR:	DP 09/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 10/03/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	N/A
		SHEET 8 OF 10	
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<b>DART AEROSPACE</b> Hawkesbury, Ontario, Canada			
TITLE <b>BOTTOM TOOL CUSHION</b>			
DWG NO. <b>RBEM623U4003102-21</b>			REV <b>B</b>
DESIGN BY:	VM 9/26/2017	.XXX ± .005	FRACTIONS ± 1/8
DRAWN BY:	VM 09/28/2017	.XX ± .01	ANGLES ± 5°
CHECKED:	SAC 09/28/2017	.X ± .1	SURFACES = 125
MFG. APPR:	DP 09/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 10/03/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	0.597 LBS
SHEET 9 OF 10			
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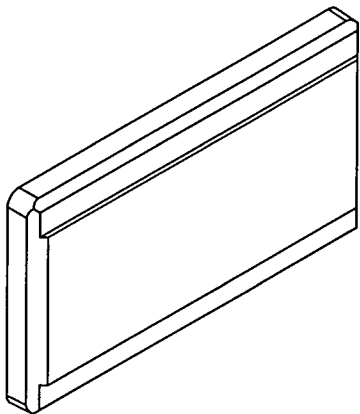
1.79

.70  
4 PL.

.25  
2 PL.


1.75  
2 PL.

SECTION A-A



- NOTES:
- 1) MATERIAL: ETHAFOAM 220, BLACK
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) SPEC: N/A
  - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
  - 6) IDENTIFICATION: N/A

RBEM623U4003102-23 TOP TOOL CUSHION

 <b>DART</b> AEROSPACE Hawkesbury, Ontario, Canada			
TITLE <b>TOP TOOL CUSHION</b>			
DWG NO. <b>RBEM623U4003102-23</b>			REV <b>B</b>
DESIGN BY:	VM 9/26/2017	.XXX ± .005 FRACTIONS ± 1/8	
DRAWN BY:	VM 09/28/2017	.XX ± .01 ANGLES ± 5°	
CHECKED:	SAC 09/28/2017	.X ± .1 SURFACES = 125	
MFG. APPR:	DP 09/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 10/03/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	0.219 LBS
		SHEET 10 OF 10	
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